

Work Order ID 80709

February-28-12 7:51:10 AM

80709*Eagle*

Page 1

Item ID: D412-785-001-403

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Faceplate

Start Date: 2/28/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/29/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *2-02-28*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-785-001-101

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg

Dwg Rev: *B*Prog Rev: *B**6061. 033*

2-Deburr if necessary

B12-2-28

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B12-2-29**(3) FF 12-02-28 (3)*

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Page 2

Item ID: D412-785-001-403

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Faceplate

Start Date: 2/28/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/29/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S 12/6/28

(13)

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

1 - Bend as per Dwg

S 12/6/29

2 - C'sink as per dwg

S 12/6/29 (3)

note left page

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

S 12/6/29

(12)

Picklist Print

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Page 1

Work Order ID: 80709

Parent Item: D412-785-001-403

Start Date: 2/28/12

Required Date: 2/29/12

Parent Item Name: Faceplate

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA 11.06.15 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	166.8860	0.098	0.2063158			
6061-T6 Sheet 0.032"													

1812-2-28

Location

Loc Qty

Loc Code

MAT021

166.886

118106

49.606

120218

63.6

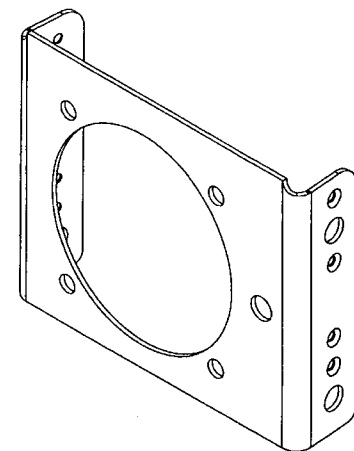
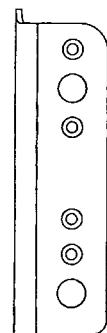
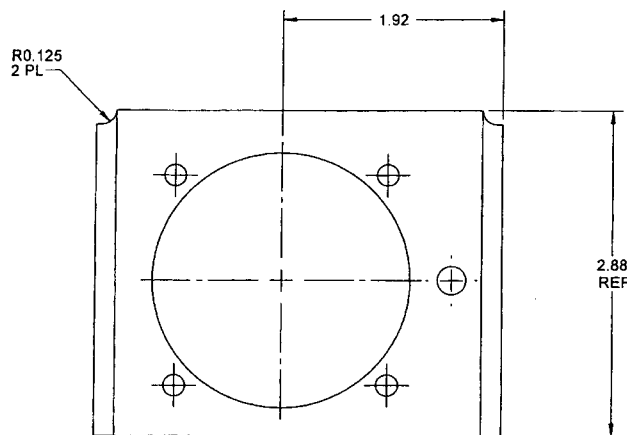
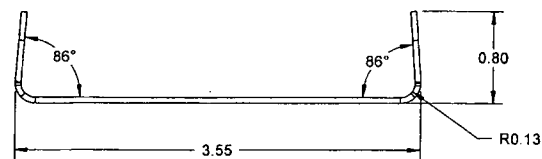
120285

53.68

118106

3

8 7 6 5 4 3 2 1



D412-785-001-403 FACE PLATE
MADE FROM D412-785-001-403F FLAT PATTERN

80709

RELEASED
10/18/25

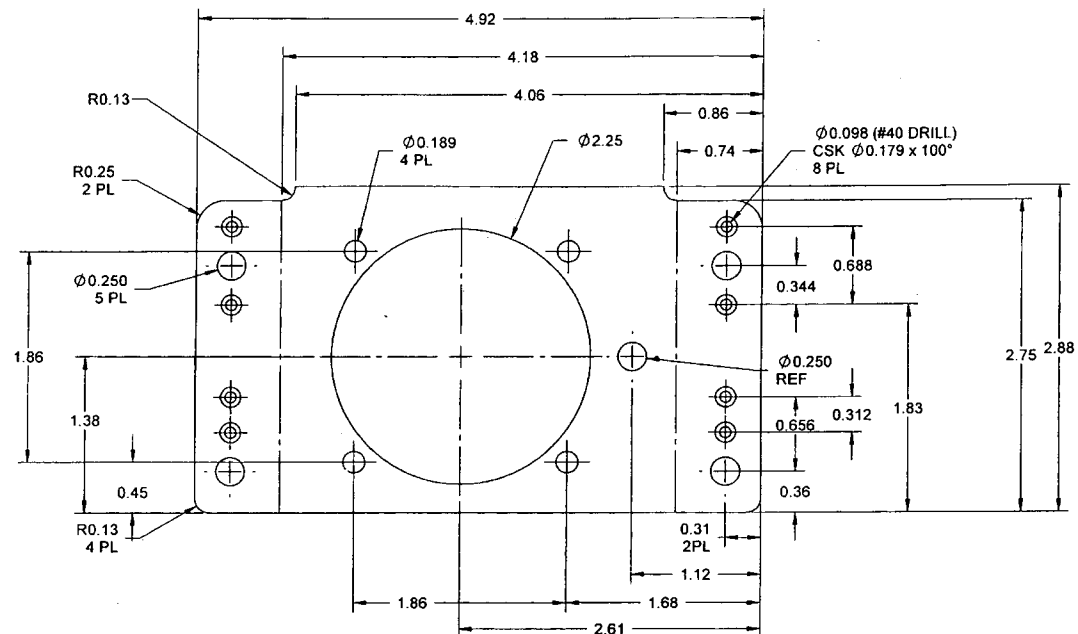
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

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DESIGN	RN	CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	DRAWING NO. REV. B
CHECKED	<i>[Signature]</i>	D412-785-001-101 SHEET 7 OF 10
MFG. APPR.	N/A	TITLE SCALE
APPROVED	<i>[Signature]</i>	LOADCELL METER MOUNT NTS
DE APPR.	N/A	
DATE	09.10.09	

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8 7 6 5 4 3 2 1



D412-785-001-403F FLAT PATTERN

80709

RELEASED
10/25/11

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	AS	CALGARY, ALBERTA, CANADA	
CHECKED	TH	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-001-101	SHEET 8 OF 10
APPROVED	SH	TITLE	SCALE
DE APPR.	N/A	LOADCELL METER MOUNT	NTS
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Dart Aerospace Ltd

W/O:		80709						WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: D412-755-001-04 PAR #: Fault Category: Small FAB NCR: Yes No DQA: Date: 12/3/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 12/3/11

NCR: <u>12-1233</u>		WORK ORDER NON-CONFORMANCE (NCR) # <u>77.64</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/11	140	1 part is scrap add .810 side land but middle Too small has to put min GP tolerance to have min Tolerance on 3.55 R.C. Process	S 12/02/11 257042	Scrap a destroy workplace	S 12/02/11	S 12/02/11	S 12/02/11 257042	S 12/02/11

NOTE: Date & initial all entries